

Work Order ID 142794 - 2

Friday, March 11, 2016 12:54:05 PM

142794

Page 1

Item ID: PB67-43001-59 - 4
 Revision ID:
 Item Name: Adjustable Attachment Arm
 Start Date: 4/1/2016 Start Qty: 5.00
 Required Date: 4/29/2016 Req'd Qty: 5.00
 Reference:

Accept *N9000040100* Setup Start *NS1*
 Stop *NS2*

Cust Item ID:
 Customer:

split

5
 5

Approvals: Process Plan: WLF Date: 6-3-11 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-59	Rev C								

100

100

Large Fab

Large Fab

Large Fab

Memo

1- Weld -105 to -113 as per dwg and grind weld flush

2- weld 119, -117 and -115 to -113 as per dwg PB67-43001

3- pick two -271 and weld one on each side of tubing but only one need to

0.00

0.05

5

APR 02 2016

DAS
24
9-89

110

110

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

0.00

5x

DAS
43
9-89

APR 05 2016

Work Order ID 142794

Friday, March 11, 2016 12:54:05 PM

142794

Page 2

Item ID: PB67-43001-59 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Adjustable Attachment Arm
 Start Date: 4/1/2016 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 4/29/2016 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120							DAS		
QC	Memo	0.00				5x	43		APR 05 2016
Quality Control							9-89		
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
140									
Powdercoat	Memo	0.01							
Powder Coating	START TIME: 1:45 OVEN TEMPERATURE: 320° FINISH TIME: 2:15								

5x of 16/6/06

5 φ. / 16-06-1 DAS 34 9-89

Friday, March 11, 2016 12:54:05 PM

142794

Item ID: PB67-43001-59

Revision ID:

Item Name: Adjustable Attachment Arm

Start Date: 4/1/2016 Start Qty: 5.00

Required Date: 4/29/2016 Req'd Qty: 5.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run	Start	*NR1*
	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150									
QC									
Quality Control	Memo	0.00				5			DAS 38 9-89 JUN 01 2016
160		0.00							
160									
Small Fab									
Small Fab									
Small Fab	Memo	0.00				1			JUN 14 2016
	1- take -267 and transfer drill holes in -113 as per dwg PB67-430012- deburr and rivet -267 to -113 as per dwg3- assemble rest of parts as per dwg PB67-43001								
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC									
Quality Control	Memo	0.00				1			DAS 38 9-89 JUN 22 2016

Work Order ID 142794

Friday, March 11, 2016 12:54:05 PM

142794

Page 4

Item ID: PB67-43001-59 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Adjustable Attachment Arm
 Start Date: 4/1/2016 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 4/29/2016 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location <u>ME220</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.01							
Quality Control									

JUN 28 2016
 16/6/29
 16/06/29

Picklist Print

Friday, March 11, 2016 12:54:05 PM

Page 1

Work Order ID: 142794

142794

Parent Item: PB67-43001-59

PR67-43001-59

Parent Item Name: Adjustable Attachment Arm

Start Date: 4/1/2016

Required Date: 4/29/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 08-07-18 new issue DD verified by:ec
IPP Rev:B 08-11-21 Qty for BSP43 revised per W/O 43054 KJ Verified
by: eC IPP RevC 10.09.29 per revC dwg EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-121		Manufactured	No			160	Each	8.0000	1	5			
PR67-43001-121													
Square Sleeve													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		8							
				133717		2				2			
				139151		6				3			
PB67-43001-267		Manufactured	No			160	Each	0.0000	1	5			
PR67-43001-267													
Pad Attachment Assembly													
30345T21		Purchased	No			160	Each	12.0000	2	10			
30345T21													
LANYARD													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST570		12							
				M132610		12							
BSP43		Purchased	No			160	Each	88.0000	4	20			
RSP43													
RIVET													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST551		88							
				M132703		88							

JUN 09 2016

Picklist Print

Friday, March 11, 2016 12:54:05 PM

Page 2

Work Order ID: 142794

142794

Parent Item: PB67-43001-59

PB67-43001-59

Parent Item Name: Adjustable Attachment Arm

Start Date: 4/1/2016

Required Date: 4/29/2016

Start Qty: 5.00

Required Qty: 5.00

MS17984-C413

Purchased

No

160

Each

40.0000

2

10

MS17984-C413

Quick Release Pin

134627

DAS
6
9-09

Location

Loc Qty

Loc Code

over005

30

m133686

20

m134052

10

ST315

10

m134029

10

MS21042L3

Purchased

No

160

Each

2,890.000

2

10

MS21042L3

Nut

134634

DAS
6
9-09

Location

Loc Qty

Loc Code

FP001

163

m133790

163

GA

68

m133790

68

OVER007

2000

m134360

2000

ST304

659

m134039

659

MS27039-1-22

Purchased

No

160

Each

106.0000

2

10

MS27039-1-22

SCREW

4
1
5

DAS
6
9-09

Location

Loc Qty

Loc Code

ST280

106

112940

100

18057

1

M18057

5

4
1
5

JUN 09 2016

To SHORT

Friday, March 11, 2016 12:54:05 PM

Shop Packet Print

Page 2

Picklist Print

Friday, March 11, 2016 12:54:05 PM

Page 3

Work Order ID: 142794

Parent Item: PB67-43001-59

Parent Item Name: Adjustable Attachment Arm

142794

PB67-43001-59

Start Date: 4/1/2016

Required Date: 4/29/2016

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0332J

Purchased

No

160

Each

1,107.000

4

20

NAS1149D0332.I

Washer

**

~~13450~~

13-1736

Location

Loc Qty

Loc Code

CA

14

m129682

14

FP001

6

m129682

6

GA

118

m132677

118

ST260a

600

m133988

600

ST264

369

m133498

369

NAS1149DN416J

Purchased

No

160

Each

792.0000

4

20

NAS1149DN416.I

Washer

**

DAS
6
9-89

TO SMALL

Location

Loc Qty

Loc Code

GA

118

124983

118

ST270

674

124968

674

20

PB67-43001-105

Manufactured

No

100

Each

10.0000

1

5

PB67-43001-105

Plug

**

APR 02 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

10

112997

2

139144

8

2

3

Friday, March 11, 2016 12:54:05 PM

Shop Packet Print

Page 3

Picklist Print

Friday, March 11, 2016 12:54:05 PM

Page 4

Work Order ID: 142794

142794

Parent Item: PB67-43001-59

PR67-43001-59

Parent Item Name: Adjustable Attachment Arm

Start Date: 4/1/2016

Required Date: 4/29/2016

Start Qty: 5.00

Required Qty: 5.00

PB67-43001-113

Manufactured No

100

Each

10.0000

1

5

PR67-43001-113

Square Tube

**

APR 02 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

10

139145

10

PB67-43001-115

Manufactured No

100

Each

8.0000

1

5

PR67-43001-115

Tube End Plate

**

APR 02 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

8

133715

4

139146

4

PB67-43001-117

Manufactured No

100

Each

7.0000

1

5

PR67-43001-117

Hook Plate

**

APR 02 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

7

112999

1

139147

6

PB67-43001-119

Manufactured No

100

Each

8.0000

1

5

PR67-43001-119

End Cap Clevis

**

APR 02 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

8

133716

2

139150

6

Friday, March 11, 2016 12:54:05 PM

Shop Packet Print

Page 4

Picklist Print

Friday, March 11, 2016 12:54:05 PM

Page 5

Work Order ID: 142794

Parent Item: PB67-43001-59

Parent Item Name: Adjustable Attachment Arm

142794

PR67-43001-59

Start Date: 4/1/2016

Required Date: 4/29/2016

Start Qty: 5.00

Required Qty: 5.00

PB67-43001-271

Manufactured No

100

Each

9.0000

1

5

PR67-43001-271

Doubler

**

APR 02 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

9

139153

8

99965

1

PB67-43001-275

Manufactured No

160

Each

9.0000

1

5

PR67-43001-275

Doubler

**

APR 02 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

9

106423

9

DAS
22
9-89

NAS 1149 DA 616 J
3328

WASHER

20

131738
127831
127726

5

20

FF

JUN 13 2016

M327039-1-2

SCREW

109

M18057

9

FF

JUN 13 2016

MISSING 1

DAS
22
9-89

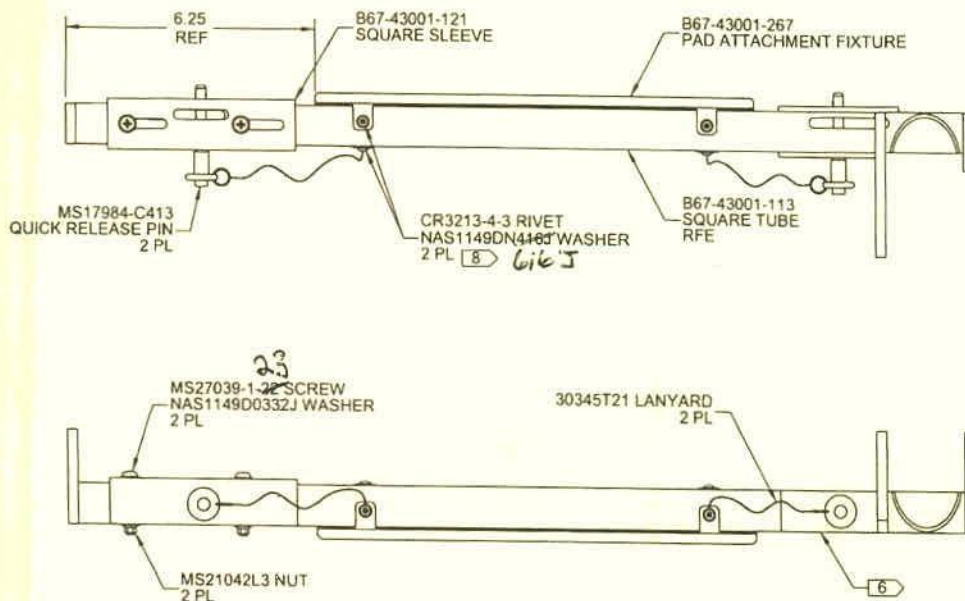
16.06.13

*

135043

1

FF

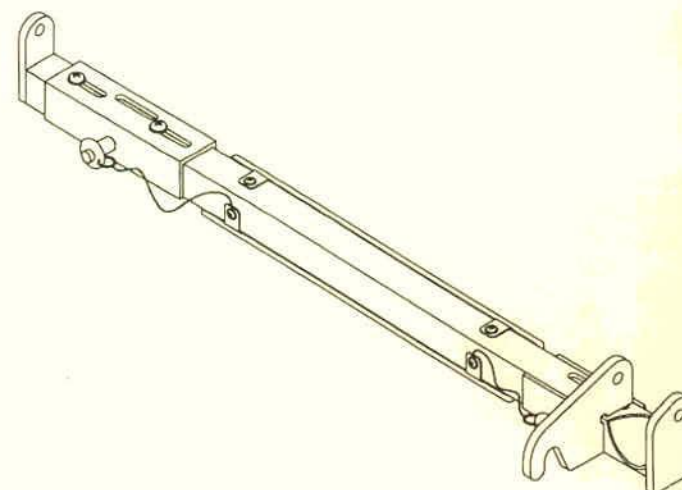


B67-43001-59 ADJUSTABLE ATTACHMENT ARM

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-59" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.21 lbs
- 8) FOLD -267 TABS OVER AND TRANSFER DRILL Ø0.130 FROM -267 TO -113 PRIOR TO INSTALL CR3213-4-3 RIVETS.

ITEM	QTY -59	P/N	DESCRIPTION
1	X	B67-43001-59	ADJUSTABLE ATTACHMENT ARM
3	1	B67-43001-121	SQUARE SLEEVE
4	1	B67-43001-267	PAD ATTACHMENT FIXTURE
6	2	30345T21	LANYARD
7	4	CR3213-4-3	RIVET (OR BSP43-4-3)
8	2	MS17984-C413	QUICK RELEASE PIN
9	2	MS21042L3	NUT
10	2	MS27039-1-22	SCREW
11	4	NAS1149D0332J	WASHER
12	4	NAS1149DN416J	WASHER

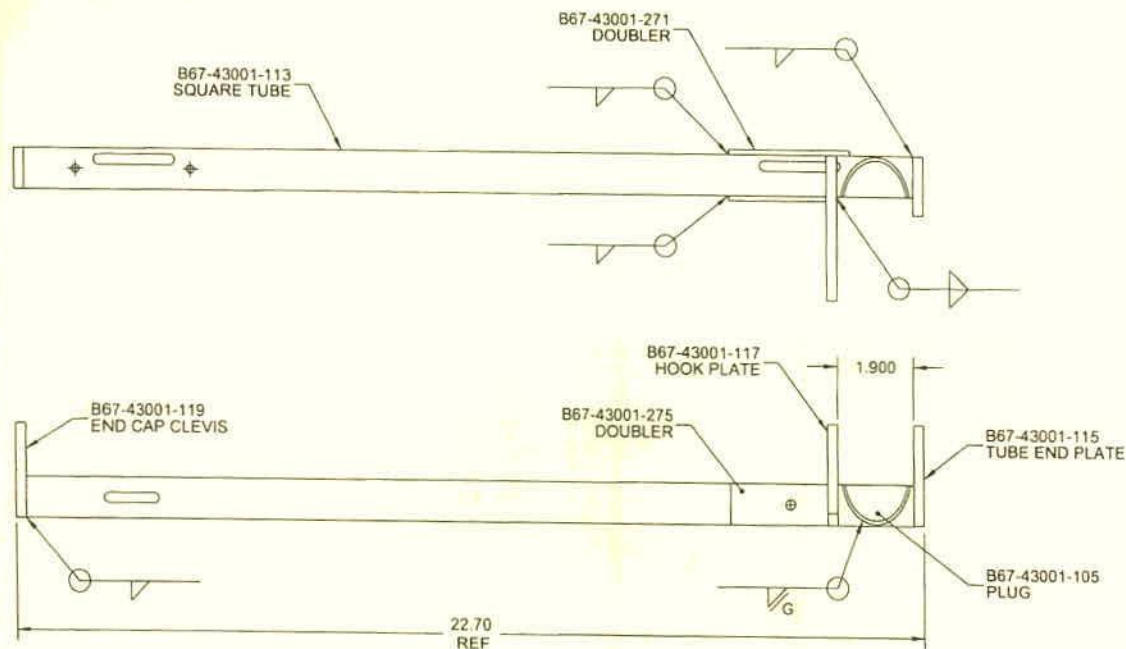


RELEASED
2010-09-16
MMO

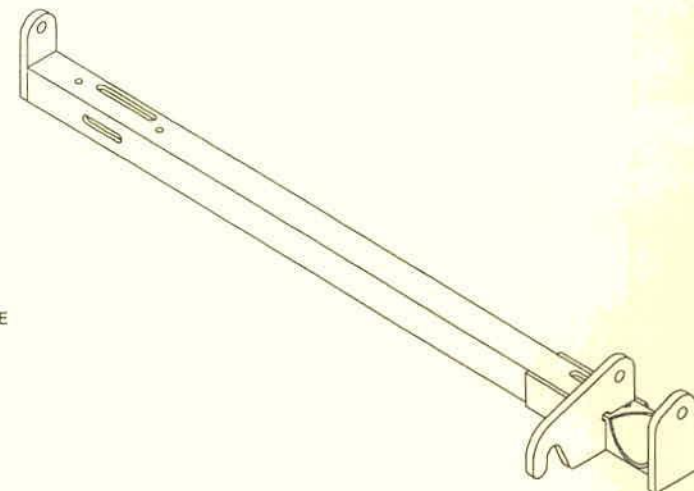
C		REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 14 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.15
REV	DESCRIPTION			BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN		DRAWING NO. B67-43001-59		REV. C	
CHECKED				SHEET 1 OF 2	
MFG. APPR.		TITLE ADJUSTABLE ATTACHMENT ARM		SCALE NTS	
APPROVED					
DE APPR.	N/A				
DATE	09.06.15				

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ITEM	QTY -59	P/N	DESCRIPTION
1	X	B67-43001-59W	ADJUSTABLE ATTACHMENT ARM WELDMENT
3	1	B67-43001-105	PLUG
4	1	B67-43001-113	SQUARE TUBE
5	1	B67-43001-115	TUBE END PLATE
6	1	B67-43001-117	HOO K PLATE
7	1	B67-43001-119	END CAP CLEVIS
8	1	B67-43001-271	DOUBLER
9	1	B67-43001-275	DOUBLER



B67-43001-59W ADJUSTABLE ATTACHMENT ARM
(WELDING DETAIL)



RELEASED
2010-08-16

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: POWDER COAT GREEN SANDTEX (4.3 5.8) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.26 lbs
 - 8) WELDING: PER QSI 004
 - 9) MASK ALL HOLES AND OPENINGS PRIOR TO POWDER COAT

DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JS	DRAWING NO.	REV. C
CHECKED	JS	B67-43001-59	SHEET 2 OF 2
MFG. APPR.	JS	TITLE	SCALE
APPROVED	ND	ADJUSTABLE ATTACHMENT ARM	NTS
DE APPR.	N/A	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
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